

Date: Monday, 22/09/2008 2:09:14 PM
 User: Julie Lecocq

Process Sheet

SPUT

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN DOOR ROLLER KIT, RH
 Job Number : 42196
 Estimate Number : 10289
 P.O. Number :
 This Issue : 22/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 40224
 Written By :
 Checked & Approved By : JLD 08.922
 Comment : Est Rev:C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from Step 1,3 KJ/DS
 Est Rev:D 08-01-28 change to rev D ECN 1104 DD

Part Number : D412698012
 Drawing Number : IIN D412-698 REV
 Project Number : N/A
 Drawing Revision : D
 Material :
 Due Date : 20/10/2008 Qty: 22 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



for JLD 08.10.08



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

502/12/12

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3121141 Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total : 66.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

3 D3121-141 Bracket Assembly 42189

4.0 D3121144 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3121-144 Bracket Assembly B421915X B4348717X

5.0 D3137043 Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

B29725 10/12/9 (22)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/09/2008 2:09:14 PM
User: Julie Lecocq

Process Sheet

Customer: CN-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 42196

Part Number: D412698012

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3137-043 Bracket Assembly

6.0

D3183044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3183-044

Bracket Assembly

43485 10X
42194 9X

8/12/12

7.0

D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total: 198.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

9 D3199-1

Bracket

42223 179X
42271 19X

8/12/12

8.0

D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D3202-1

Cover

42224

8/12/12 (22)

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/12/12 (15)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location:

8/12/12 (19)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/12
VNF 08-12-12

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST - PILOT DOOR MODIFICATION KITS

Qty -015	Qty -023	Part Number	Description
X		D412-698-015	DOOR SUPPORT KIT
	X	D412-698-023	AUTOMATIC DOOR OPENER KIT
2		D3200-1	DOOR POST BLOCK
2		D3200-3	DOOR WEDGE
2		D3201-1	DOUBLER
1		D3201-3	ANGLE
1		D3201-4	ANGLE
	1	D3552-11	GAS SPRING
	1	D3594-5	DOOR DOUBLER
	1	D3594-043	FLOOR DOUBLER ASSEMBLY, LH
	1	D3594-044	FLOOR DOUBLER ASSEMBLY, RH
	2	D3622-1	BALL STUD
	1	MS21073L5	ANCHOR NUT
	2	MS20426AD4-4	RIVET
12		AN960JD10L	WASHER
	2	AN960JD516L	WASHER
12		MS21042L3	NUT (OR MS21042-3)
12		MS24693-S277	SCREW

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Revision: E
Date: 08.05.01

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty -019	Qty -021	Qty -031	Qty -032	Qty -033	Qty -035	Part Number	Description
X						D412-698-019	BEARING OVERHAUL KIT
	X					D412-698-021	REPLACEMENT SHIM KIT
		X				D412-698-031	CABIN DOOR ROLLER KIT, LH
			X			D412-698-032	CABIN DOOR ROLLER KIT, RH
				X		D412-698-033	REPLACEMENT DOOR TRACK KIT
					X	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-241	BEARING ASSEMBLY
1						D3137-3	GUIDE
1						D3137-5	WASHER
2						D3183-045	BEARING ASSEMBLY
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			1			D3121-144	BRACKET ASSEMBLY
		1	1			D3137-043	BRACKET ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
			1			D3183-044	BRACKET ASSEMBLY
		1	1	1		D3202-3	COVER
		3	3			D3674-041	BRACKET ASSEMBLY
		9	9	9		D3675-1	BRACKET
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
					2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
					12	AN960JD10L	WASHER
					12	MS21042L3	NUT
					12	MS24694-S58	SCREW
1						MS24694-S101	SCREW

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